

Work Order ID 58518

Monday, May 10, 2010 8:16:05 AM



Page 1

| | | | | | | |
|----------------|---|------------|------|-------|---------------|--|
| Item ID: | DSI 9420-013 | Accept | | Setup | Start | |
| Revision ID: | B | | | | Stop | |
| Item Name: | Run-On Landing Wearplate Upgrade, High Gear | | | | | |
| Start Date: | 5/10/2010 | Start Qty: | 6.00 | | Cust Item ID: | |
| Required Date: | 5/10/2010 | Req'd Qty: | 6.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|-----------|-------|----------------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | <u>mf</u> | Date: | <u>10-5-10</u> | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| DSI 9420 | B | | | | | | | | |

| | | | | | | | | | |
|------------------|---|------|--|--|--|--|--|--|--|
| 100 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| DC | | 0.00 | | | | | | | |
| Document Control | Memo | | | | | | | | |
| | Photocopy bluefile & type labels per PPP DSI 9420-013 | | | | | | | | |
| | CHG001 | | | | | | | | |
| | | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| | | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | | 0.00 | | | | | | | |
| Quality Control | Memo | | | | | | | | |
| | | | | | | | | | |

H for BG 10/05/10

Pick/10 (6)

(70)

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 58518

Monday, May 10, 2010 8:16:05 AM

Page 2

Item ID: DSI 9420-013 Accept

Revision ID: B

Item Name: Run-On Landing Wearplate Upgrade, High Gear

Start Date: 5/10/2010 Start Qty: 6.00

Required Date: 5/10/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9420-013

Location: _____

PPP rev: _____

121

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/07/10 (6)**10/05/10**MF 10-5-10*

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|--|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Monday, May 10, 2010 8:16:04 AM

Page 1

Work Order ID: 58518

Parent Item: DSI 9420-013

Parent Item Name: Run-On Landing Wearplate Upgrade, High Gear

Start Date: 5/10/2010

Required Date: 5/10/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|

| | | | | | | | | | | | | |
|-----------------|--|-----------|----|--|--|-----|------|----------|------|--|--|--|
| AN3-37A Bolt | | Purchased | No | | | 110 | Each | 713.0000 | 42 7 | | | |
|-----------------|--|-----------|----|--|--|-----|------|----------|------|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST353 | 713 | |
| 105425 | 213 | 105425 |
| 111668 | 500 | |

| | | | | | | | | | | | | |
|---------------------|--|-----------|----|--|--|-----|------|--------|------|--|--|--|
| AN960JD10 Washer | | Purchased | No | | | 110 | Each | 0.0000 | 42 7 | | | |
|---------------------|--|-----------|----|--|--|-----|------|--------|------|--|--|--|

| | | | | | | | | | | | | |
|----------------------------|--|--------------|----|--|--|-----|------|---------|------|--|--|--|
| D2649 Cross Bolt Spacer | | Manufactured | No | | | 110 | Each | 18.0000 | 12 2 | | | |
|----------------------------|--|--------------|----|--|--|-----|------|---------|------|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 18 | |
| 55000 | 18 | 55000 |

| | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|--------|---|--|--|--|
| D3805-043 Wearplate Assembly Fwd, High Gear | | Manufactured | No | | | 110 | Each | 2.0000 | 1 | | | |
|--|--|--------------|----|--|--|-----|------|--------|---|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP18 | 2 | |
| 55353 | 2 | 55353/10 |

| | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|--------|--|--|--|--|
| D3805-047 Wearplate Assembly Aft, High Gear | | Manufactured | No | | | 110 | Each | 1.0000 | | | | |
|--|--|--------------|----|--|--|-----|------|--------|--|--|--|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP18 | 1 | |
| 55354 | 1 | 55354 10 |

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | |
|------|------|--------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, May 10, 2010 8:16:04 AM

Work Order ID: 58518

Parent Item: DSI 9420-013

Parent Item Name: Run-On Landing Wearplate Upgrade, High Gear


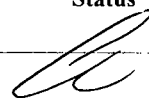
Start Date: 5/10/2010

Required Date: 5/10/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|---|
| D3873-1  Bushing | | Manufactured | No | | | 110 | Each | 163.0000 | 87 14 ✓ | | |  |

Location

Loc Qty

Loc Code

ST093

104

57615

104

ST094

59

55326

19

57352

40

57615 25x

55326 19x

57352 40x

MS21042-3

Purchased

No

110

Each

160.0000

ya 7 ✓

USE MS21042L3

Location

Loc Qty

Loc Code

ST299

160

111650

60

114597

100

m113644

Rec'd 10 (6)

Monday, May 10, 2010 8:16:04 AM

Shop Packet Print

Page 2

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|--|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

9.0 DSI 9420-011/-013 RUN-ON LANDING WEARPLATE UPGRADE KIT INSTALLATION

- 9.0.1 Remove the D206-642-111/-112/-211/-212/-213/-214 Skidtube per Section 32.1 of ICA-D206-642 Rev. 1 or earlier. Remove existing wearplates. Inspect the bottom of the tube for damage and touch up finish per Section 5.2.11 of ICA-D206-642 Rev. 1 or earlier. Plug existing wearplate inserts using Sikaflex-241/-291 or Proseal 890.
- 9.0.2 Remove qty(10) D2651-1 Plugs where the AN3 Bolts will be inserted to install the run-on landing wearplate assemblies. Refer to Figure 2.
- 9.0.3 Locate and temporarily install the Wearplate Assemblies per Figure 1. On both sides of the skidtube, transfer drill qty(2) Ø0.375" holes from the Wearplate Assembly to the Skidtubes as shown in Figure 2. Countersink the holes on both sides to Ø0.450" X 45°. Deburr.
- 9.0.4 Install D2649 Spacer per Sections A-A or B-B using Magnobond 6398. Grind flush as required. Allow Magnobond to cure per manufacturer's instructions.
- 9.0.5 Install the D3805-XXX Wearplate Assemblies using the qty(7) AN3-37A bolts and associated fasteners, as shown in Figure 1 of this service instruction. Torque fasteners to 15-25 in-lb (1.7-2.8 N-m).
- 9.0.6 Reinstall the Skidtube on the aircraft per Section 32.2 of ICA-D206-642 Rev.1 or earlier.
- 9.0.7 Update weight and balance information per Section 6.0 of this service instruction. Customers upgrading D206-642-111/-112 Skidtubes should adopt Weight & Balance of D206-642-113/-114 Skidtubes and customers upgrading D206-642-211/-212/-213/-214 Skidtubes should adopt Weight & Balance of D206-642-215/-216/-217/-218 Skidtubes.

10.0 DSI 9420-011/-013 PARTS LIST

| Qty -011 | Qty -013 | Part Number | Description |
|----------|----------|--------------|---|
| X | X | DSI 9420-011 | RUN-ON LANDING WEARPLATE UPGRADE KIT, LOW GEAR |
| | X | DSI 9420-013 | RUN-ON LANDING WEARPLATE UPGRADE KIT, HIGH GEAR |
| 2 | 2 | D2649 | SPACER |
| 1 | | D3805-041 | FWD WEARPLATE ASSY |
| 1 | | D3807-1 | * GASKET (1) |
| | 1 | D3805-043 | FWD WEARPLATE ASSY |
| | 1 | D3807-3 | * GASKET (2) |
| 1 | | D3805-045 | AFT WEARPLATE ASSY |
| 1 | | D3807-5 | * GASKET (3) |
| | 1 | D3805-047 | AFT WEARPLATE ASSY |
| | 1 | D3807-7 | * GASKET (4) |
| 14 | 14 | D3873-1 | BUSHING |
| 7 | 7 | AN3-37A | BOLT |
| 7 | 7 | AN960JD10 | WASHER |
| 7 | 7 | MS21042-3 | NUT (OR MS21042L3) |

NOTES:
 (1) DENOTES THAT PART IS INCLUDED WITH D3805-041 ASSEMBLY ABOVE
 (2) DENOTES THAT PART IS INCLUDED WITH D3805-043 ASSEMBLY ABOVE
 (3) DENOTES THAT PART IS INCLUDED WITH D3805-045 ASSEMBLY ABOVE
 (4) DENOTES THAT PART IS INCLUDED WITH D3805-047 ASSEMBLY ABOVE

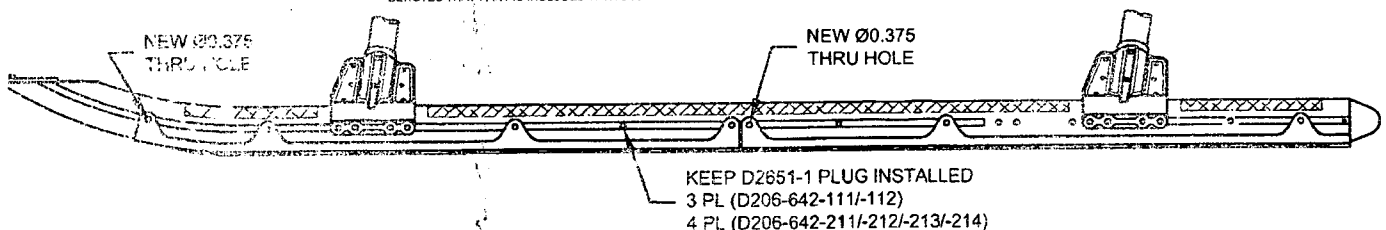


FIGURE 2: D206-642-111/-112/-211/-212/-213/-214 SKIDTUBE MOD
 (D206-642-111/-112 SHOWN - D206-642-211/-212/-213/-214 SIMILAR)

| | | | |
|------------|----------|--|--------------|
| DESIGN | 9420 | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | HA | DRAWING NO. | REV. B |
| MFG. APPR. | N/A | DSI 9420 | SHEET 6 OF 6 |
| APPROVED | HA | TITLE | SCALE |
| DE APPR. | HA | SKIDTUBE INSTALLATION | NTS |
| DATE | 09.03.25 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries